

GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:33:59 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 32078		Part Number	: D2573		
Estimate Number	: 10533		Drawing Number	: D2573 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/26/2007	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2007		
Previous Run	: 31721		Qty:	10	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>385353 (10)</u> <u>En 07/05/03</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>022075</u> Double check by: <u>SF</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <u>En 1/20 07/06/03</u>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u>En 1/20 07/06/03</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>En 1/20 07/06/03</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number: 32078		Part Number: D2573
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		J.F. 07/06/04 (10)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		fx 07/06/04 (10)
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat - OLIVE DRAB GREEN (Ref: 4.3.5.1) as per QSI 005 4.3		m/04476. fx 07/06/04 (10)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		EP 07/06/05 (10)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		G05/06/05 (Q3)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07/06/05 (10)
Job Completion 		6/07/06/05

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD				Work Order:	32078
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		0.497	0.505	0.502	0.504		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.502	0.503		
J	1.174	1.184		1.175	1.178	1.178	1.177		
K	0.558	0.578		0.565	0.570	0.571	0.570		
L	1.174	1.184		1.175	1.178	1.178	1.177		
M	1.365	1.375		1.368	1.369	1.369	1.368		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.121	4.121	4.120		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.127	0.130	0.124	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.244	0.246	0.241		
W	0.115	0.135		0.127	0.134	0.130	0.130		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.362	0.365		
AA	0.470	0.530		0.520	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.633	0.633	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.255	0.253	0.254		
AE	1.500	1.520		1.510	1.509	1.512	1.511		
AF	0.115	0.135		0.131	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.253	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.001	2.000		
AJ	0.023	0.043		0.032	0.033	0.033	0.033		

Accept/Reject

Measured by:	<i>En/Arn</i>	Audited by:	<i>SA</i>
Date:	07/06/01	Date:	07.06.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>RF</i> <i>SA</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32078
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

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B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.501	3.497	3.495		
D	1.745	1.755		1.749	1.748	1.749	1.748		
E	7.990	8.010		8.003	8.003	8.006	8.004		
F	0.490	0.510		0.500	0.499	0.500	0.499		
G	0.257	0.262	DT8683	0.259	0.259	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.503	0.503	0.500	0.501		
J	1.174	1.184		1.178	1.179	1.178	1.175		
K	0.558	0.578		0.569	0.570	0.566	0.564		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.368	1.369		
N	2.495	2.505		2.500	2.500	2.497	2.498		
O	4.119	4.129		4.121	4.122	4.121	4.121		
P	0.115	0.135		0.126	0.126	0.126	0.126		
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Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.506	0.500	0.500		
AB	0.615	0.635		0.628	0.626	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.253	0.243	0.248		
AE	1.500	1.520		1.511	1.512	1.514	1.513		
AF	0.115	0.135		0.126	0.129	0.135	0.135		
AG	0.240	0.280		0.265	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.248	0.247	0.246		
AI	2.000	2.020		2.000	2.002	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *SMR / En*
 Date: *07/06/02*

Audited by: *J-F*
 Date: *07/06/02*

Rev	Date	Change	Revised by	Approved
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F	0.490	0.510		0.499	0.500				
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H	0.375	0.380	DT8684	0.377	0.377				
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Accept/Reject									

Measured by:	CP	Audited by:	J.F.
Date:	02/06/09	Date:	07/06/09

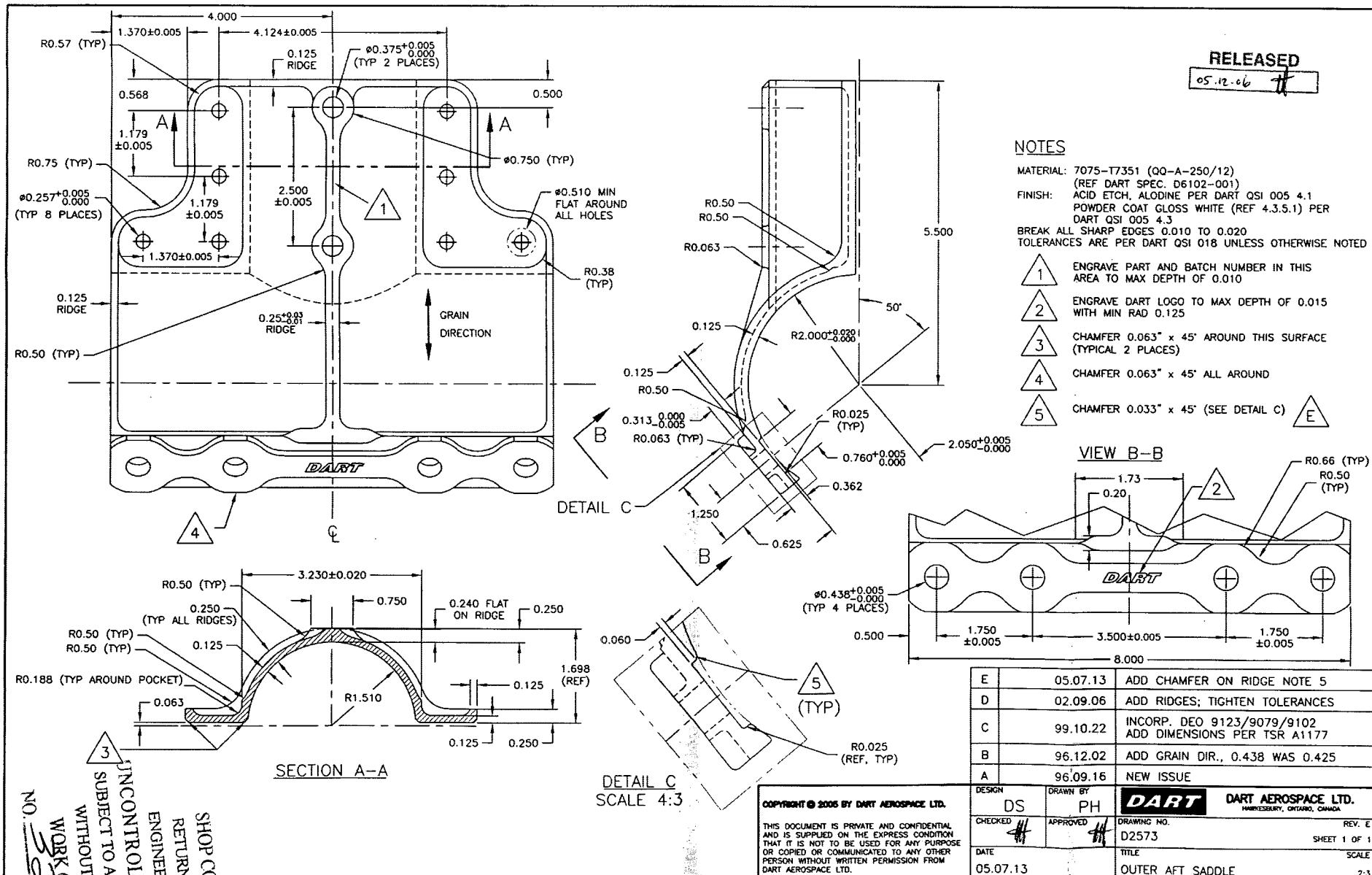
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 32078
ENGINEERING
RETURN TO
SHOP COPY

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